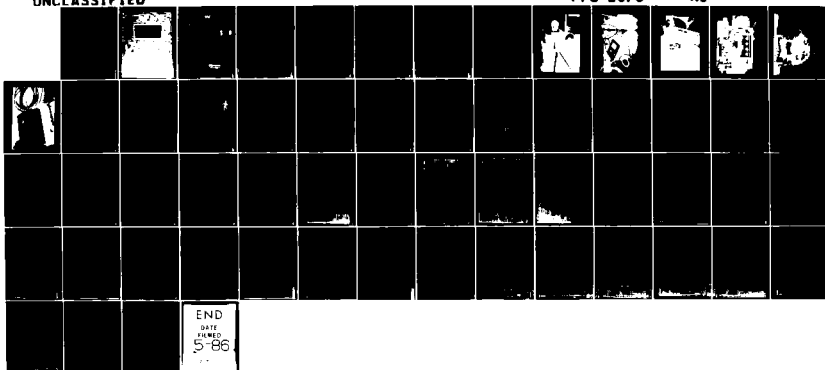
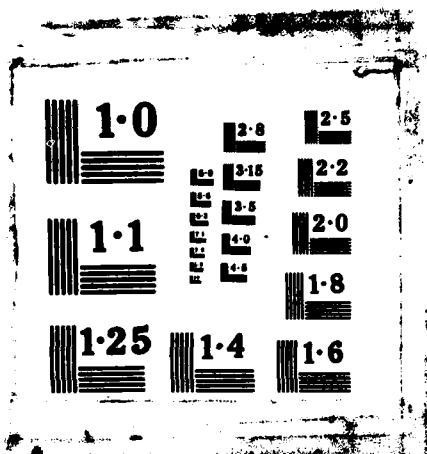


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Science Applications International Corporation

ELECTRO-OPTICAL DEVELOPMENT SYSTEM  
FINAL REPORT

DTIC  
ELECTE  
APR 10 1986

Contract DAAK70-84-C-0034  
Period of Performance: 04/16/84 through 09/30/85

Submitted to: Night Vision and Electro-Optical Laboratory  
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1.0

## INTRODUCTION

This final report describes the successful delivery of all required items under the contract, as well as additional work not originally anticipated at the time the proposal was written. The relatively long time delay of approximately ten months in contract award meant that customer requirements had evolved since the proposal was prepared. Science Applications International Corporation (SAIC) provided flexible response in order to satisfy evolving requirements, as SAIC has done during previous contracts.

All requested tasks were completed, but not without technical challenges. The sections which follow describe each of these tasks.

2.0

## LLLTV WIDE-FIELD SMALL-APERTURE SYSTEM

The original statement of work called for the development of an integrated system utilizing micro-channel plate (MCP) image intensification of a solid-state detector array with C-mount interface to a small diameter cystoscope. This system was delivered utilizing GFE customer components, since the customer had acquired these components during the contracting process. This GFE mode of satisfying the requirement was suggested by the customer in order to free contract resources for other tasks.

3.0

## INTERFACES FOR (PORTAL APERTURE IMAGE REFOCUSING) (PAIR)

Five complete PAIR units were built and delivered. This task required devising a sophisticated optical design utilizing nine optical elements, in addition to a unique mechanical housing and coupling mechanism. The entire task was completed within three months due to a pressing customer application. The design details of this device are not included here at customer request.

#### 4.0 FAST TELEPHOTO LENS

The requirement for a low focal ratio telephoto lens to be used with a low light level television (LLLTV) camera was first addressed by designing a Wright camera configuration (Figure 1A). The fabrication of the corrector plate and mirror was attempted by a private local optical shop specializing in aspheres. The company was unsuccessful in their attempt to fabricate the elements for a fast ( $F = 2$ ) Wright, however, due to the need to manufacture optical elements differing from a spherical surface by about 300 fringes. A different configuration proved necessary.

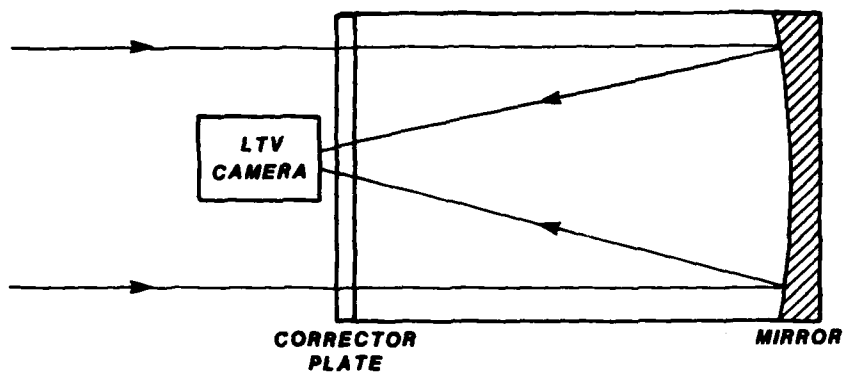
A successful  $F = 1.5$  telephoto lens was fabricated using the Schmidt camera configuration of Figure 1B. This fast focal ratio results in a 78% brightness increase over the Wright design, and an even larger advantage when compared to commercially available optics in the 300 millimeter or longer focal lengths. The one disadvantage of the system is the long tube length which is twice the focal length. Design studies have indicated that good performance would be available over the desired field of view from a shortened Schmidt configuration with total physical length comparable to the focal length, but it was not possible to try this under the present contract.

#### 5.0 ALTITUDE-AZIMUTH MOUNTS

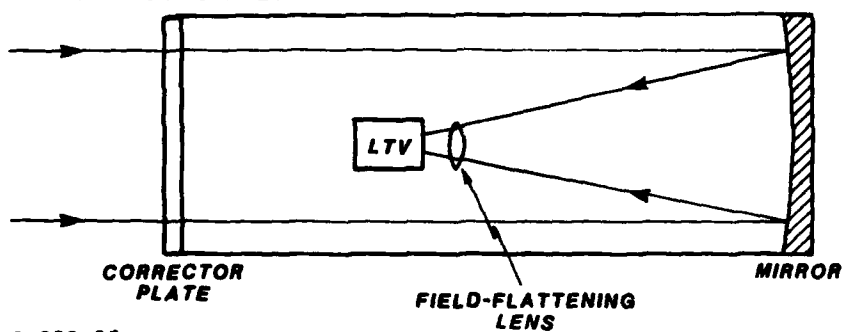
Two complete alt.-azimuth mounts were designed, fabricated, and delivered. The first was a prototype which exceeded customer requirements in that it had proportional joystick control with finer motion resolution than needed (Figures 2, 3, 4 and 5). The second version for field use was developed using customer feedback from experience with the prototype. The operational mount (Figures 6 and 7) weighs only about 4.5 pounds compared to 27 pounds for the prototype. This small mount uses a 4 pound control box with simple direction and motion rate controls. Preliminary drawings



**A. WRIGHT CAMERA**



**B. SCHMIDT CAMERA**



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Figure 1. Fast Telephoto Lens Configurations



Figure 2. Prototype Alt.-Azimuth Mount

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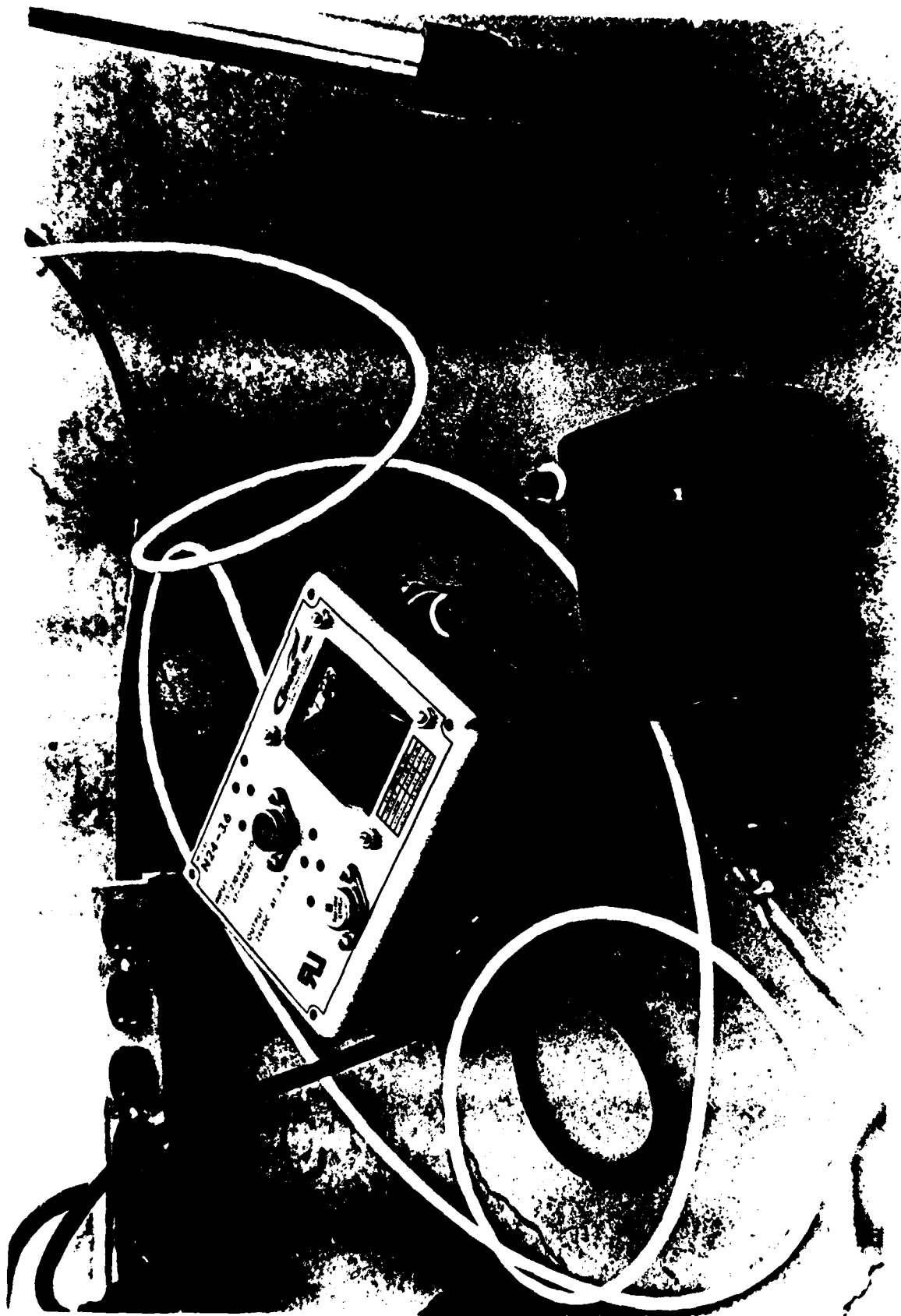


Figure 3. Prototype Proportional Joystick Control

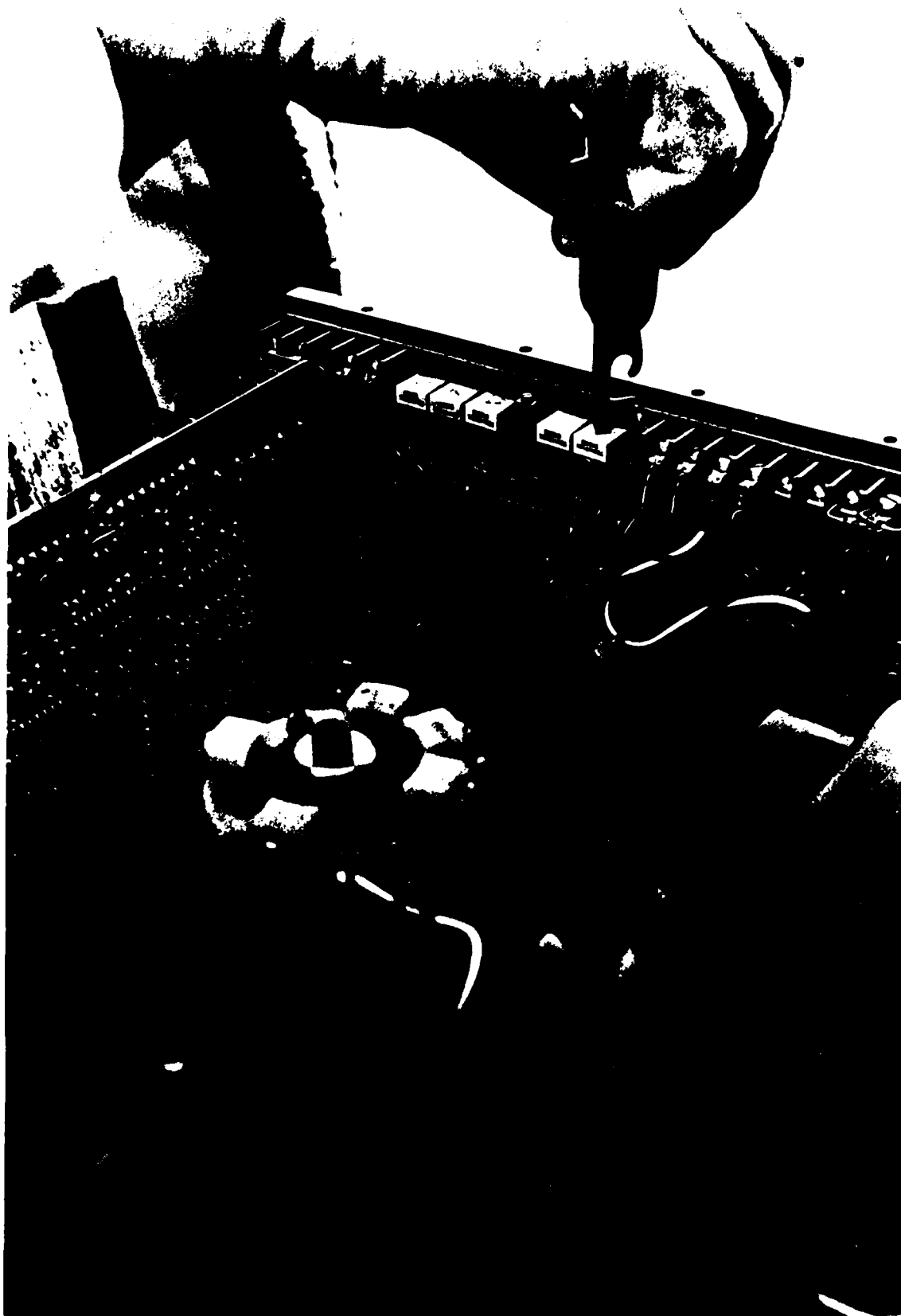


Figure 4. Prototype Mount With Cover Removed

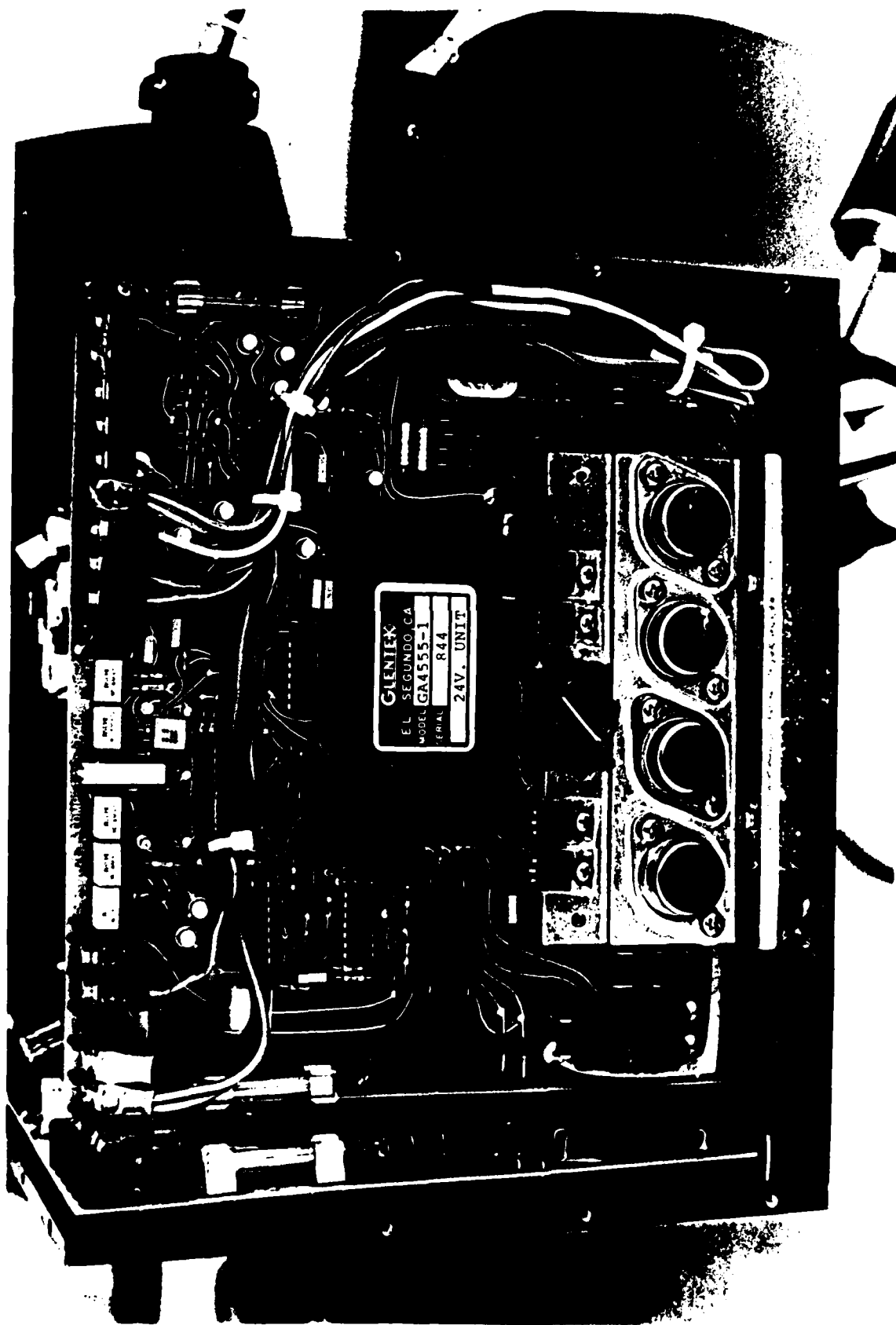


Figure 5. Internal Prototype Mount Electronics

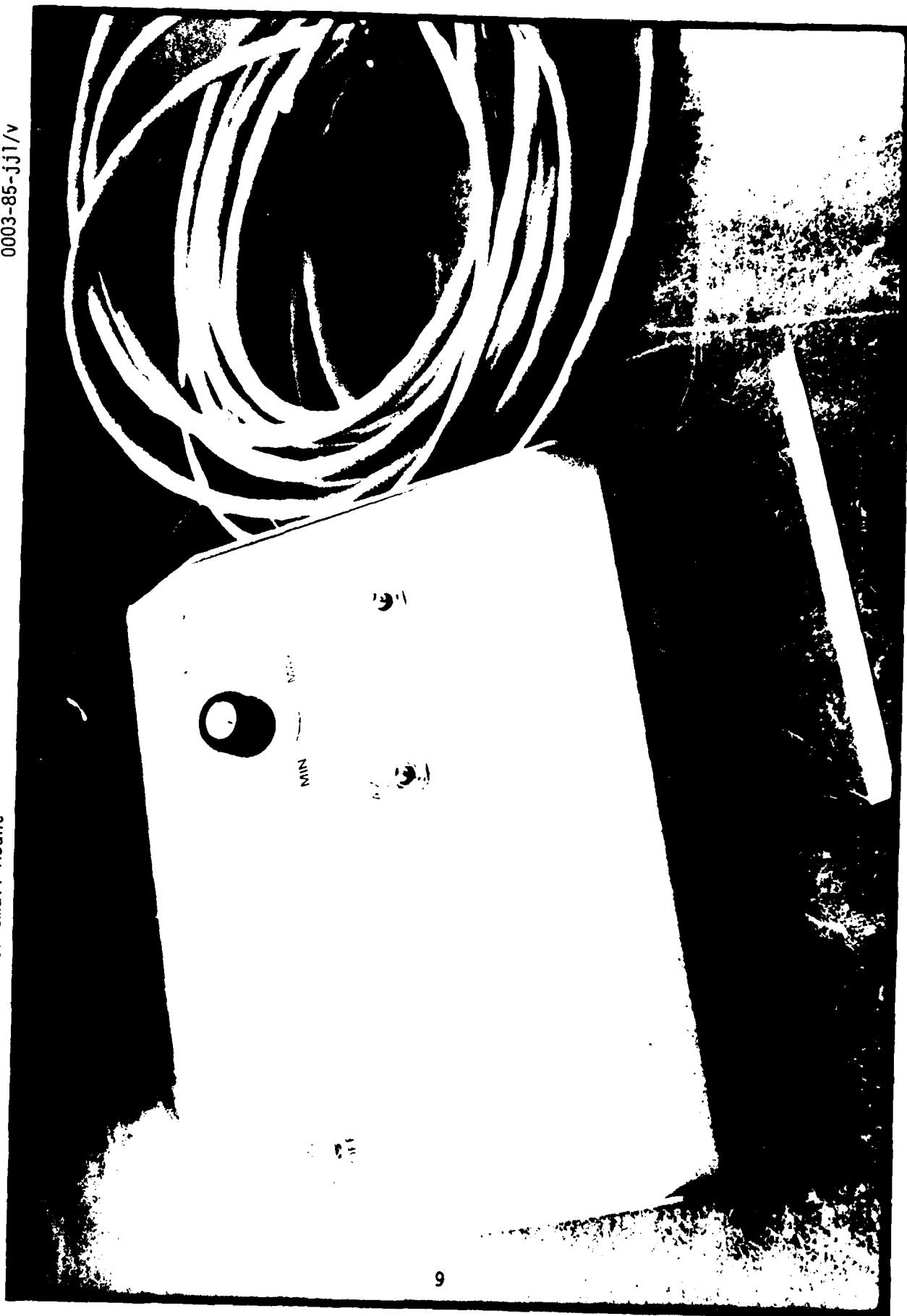


Figure 6. Small Operational Mount

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Figure 7. Control Box For Small Mount

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for the small mount are provided in Appendix B.

#### 6.0 IMAGING SYSTEM AND HUMAN EYE PERFORMANCE MODELING

Appendix A details modeling in support of a customer requirement for covert near-infrared imaging.

#### 7.0 DISCUSSION

Responsive support of diverse and evolving customer requirements has been provided including the design, development, and delivery of several new systems. Some of these systems, such as PAIR and the small alt.-azimuth mount are nearly fully developed, while the fast telephoto lens should be refined to reduce its size and decrease scattered light from off-axis sources.



APPENDIX A

MODELING OF SURVEILLANCE SENSORS AND MODELING  
OF THE HUMAN EYE FOR COVERT NEAR-INFRARED IMAGING

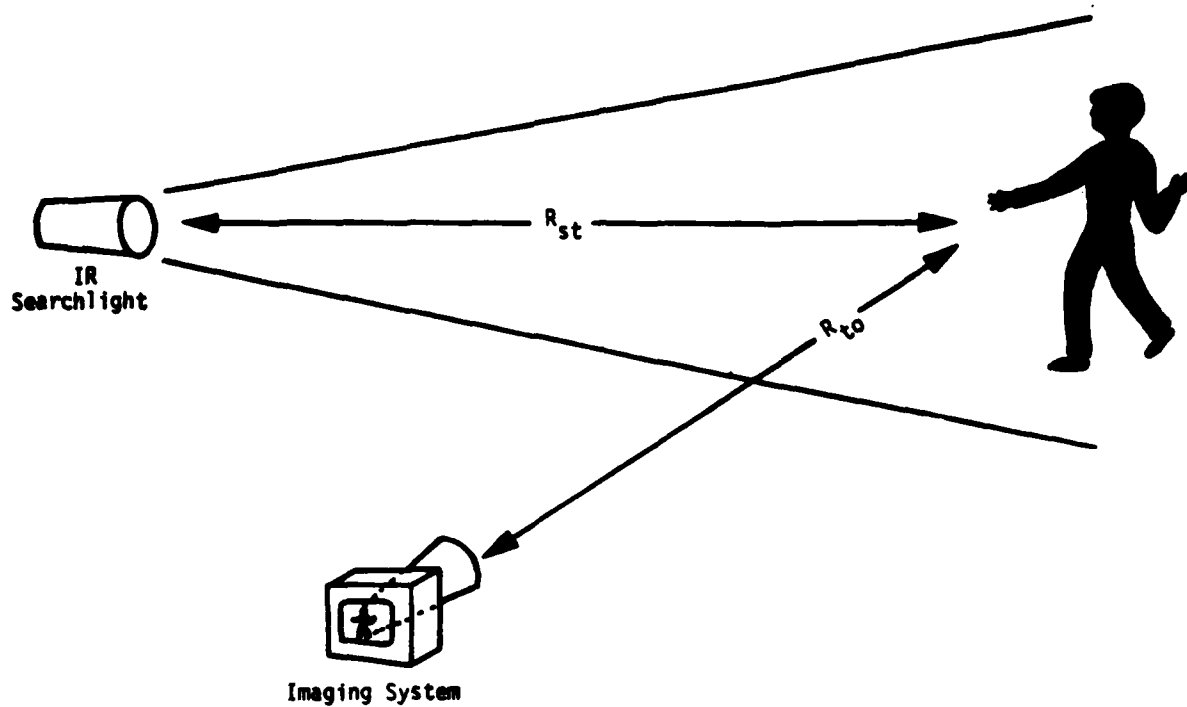
A.1 SUMMARY

It is desired to determine the feasibility of designing an active illuminator/near infrared imager combination which will allow the covert surveillance of humans. The infrared response of the eye extends somewhat further into the red than is often assumed. This eye response to about 1 micrometer wavelength [1] requires more attention to detail in solving the problem than might at first be supposed. An operational illumination system [2] in use for this purpose is in fact easily detected by the eye even though a filter which blocks essentially all of the light shortward of about 800 nanometers is used.

A radiometric model is constructed and exercised to determine if relatively simple modifications to existing equipment can be made which will solve the problem. It has been found that the use of a longer wavelength optical filter only increases the intensified television surveillance system advantage over the eye by about 3dB. The best solution available with the present illuminators is to increase the TV optical aperture area to  $675 \text{ cm}^2$  (the equivalent of about an 11-inch clear aperture optic with central obstruction). This aperture will allow operation to a range of about 200 meters without exceeding the illuminator intensity which is detectable by the eye.

A.2 RADIOMETRIC MODEL

Part of the difficulty in achieving covert illumination arises due to the direct illumination of the human in Figure A1. The eye is looking directly down the collimated searchlight beam, whereas the low light level television ( $L^3\text{TV}$ ) must use diffusely reflected indirect illumination. The monochromatic power incident on the eye is:



G-262-85

Figure A1. Problem Geometry

$$\phi_{\text{eye}}(\lambda) = \frac{L_s(\lambda) \tau_f(\lambda) A_s A_{\text{eye}}}{R_{\text{st}}^2}, \quad (1)$$

where:  $L_s(\lambda)$  is the radiance of the searchlight source,  
 $\tau_f(\lambda)$  is the transmissivity of the IR searchlight filter,  
 $A_s$  is the source area,  
 $A_{\text{eye}}$  is the eye aperture area, and  
 $R_{\text{st}}$  is the searchlight to eye distance.

The power incident on a pixel sized region of the  $L^3\text{TV}$  photocathode can be decomposed to clarify the nature of the indirect illumination:

$$\begin{aligned} \phi_{\text{pc}}(\lambda) &= (\text{power incident on a target pixel}) \\ &\times \frac{(\text{target pixel reflectivity})}{(\text{reflectance solid angle})} \\ &\times (\text{solid angle of } L^3\text{TV optics at the target}) \quad (2) \end{aligned}$$

In calculating the power incident on a target pixel, some concern may arise over the highly collimated nature of the searchlight beam. This collimation might be thought to invalidate the apparent  $R^{-2}$  dependence which arises in radiative transfer relations similar to Equation (1). It is less likely to include an error in the radiometric model if an expression such as (1) is thought of in terms of geometrical partitioning of the radiant power:

$$\begin{aligned} \phi_{\text{eye}}(\lambda) &= (\text{power emitted by the searchlight}) \\ &\times (\text{fraction of power intercepted by the eye}) \\ &= \phi_s(\lambda) \left( \frac{\Omega_{\text{eye}}}{\Omega_s} \right) = \left( \frac{\phi_s(\lambda)}{\Omega_s} \right) (\Omega_{\text{eye}}) \\ &= \left( L_s(\lambda) \tau_f(\lambda) A_s \right) \left( \frac{A_{\text{eye}}}{R_{\text{st}}^2} \right), \quad (3) \end{aligned}$$

where:  $\Omega_{eye}$  is the solid angle subtended by the eye at the searchlight, and

$\Omega_s$  is the solid angle into which the searchlight emits.

It is assumed here that the searchlight emits uniformly throughout  $\Omega_s$  to eliminate the necessity of integrating over angular dependence. It is then apparent that as long as

$$\frac{\Omega_{eye}}{\Omega_s} \leq 1, \quad (4)$$

the  $R^{-2}$  dependence of Equation (3) which arises from the calculation of  $\Omega_{eye}$  holds. Similarly, Equation (2) may be expressed:

$$\phi_{pc}(\lambda) = \left( \frac{L_s(\lambda) \tau_f(\lambda) A_s A_t}{R_{st}^2} \right) \left( \frac{\rho_t(\lambda)}{\pi} \right) \left( \frac{A_0}{R_{to}^2} \right), \quad (5)$$

where:  $A_t$  is the target pixel area,

$\rho_t(\lambda)$  is the target pixel reflectivity,

$A_0$  is the area of the  $L^3TV$  optics,

$R_{to}$  is the target to  $L^3TV$  distance,

and it is assumed that

$$\frac{\Omega_t}{\Omega_s} \leq 1, \quad (6)$$

with uniform illumination throughout  $\Omega_s$ .

The signal-to-noise ratio for the eye looking at the searchlight as well as for the  $L^3TV$  detecting the target reflectance signal can now be calculated. The  $L^3TV$  is assumed to be microchannel plate intensified and quantum noise limited in the sense that [3]:

$$SNR_{L^3TV} = \sqrt{n \eta_{pc} F_{MCP}}, \quad (7)$$

where:  $n$  is the number of photons incident on a pixel sized area

of the photocathode,

$\eta_{pc}$  is the photocathode quantum efficiency, and  
 $F_{MCP}$  is the microchannel plate fill factor.

The number of photons is:

$$n = \frac{\lambda \phi_{pc}(\lambda) \Delta t}{hc}, \quad (8)$$

where:  $\Delta t$  is the integration time,

$h$  is Planck's constant ( $6.63 \times 10^{-34}$  Jsec),

$c$  is the speed of light, and

$\phi_{pc}(\lambda)$  is given by Equation (5).

The final signal-to-noise expression integrated over the spectral response of the  $L^3TV$  is:

$$SNR_{L^3TV} = \left[ \Delta t \int_0^\infty \frac{\lambda L_s(\lambda) \tau_f(\lambda) A_s A_{t0} \rho_t(\lambda) \eta_{pc}(\lambda) F_{MCP}}{\pi h c R_{st}^2 R_{to}^2} d\lambda \right]^{1/2}. \quad (9)$$

The signal-to-noise for the eye is taken to be:

$$SNR_{eye} = \left[ \int_0^\infty \frac{\phi_{eye}(\lambda)}{T_{eye}(\lambda)} d\lambda \right]^{1/2}, \quad (10)$$

where:  $T_{eye}(\lambda)$  is the eye threshold.

Therefore,

$$SNR_{eye} = \left[ \int_0^\infty \frac{L_s(\lambda) \tau_f(\lambda) A_s A_{eye}}{T_{eye}(\lambda) R_{st}^2} d\lambda \right]^{1/2}. \quad (11)$$

While the eye is very much less sensitive than the  $L^3TV$  at wavelengths longer than 700 nanometers, the geometric advantage most

clearly seen in the  $R^{-2}$  dependence of Equation (11) versus the  $R^{-4}$  dependence of Equation (9) indicates some of the difficulty in solving the problem.

A signal-to-noise ratio of little more than 1 may allow eye detection of the searchlight, while the  $L^3TV$  must provide a somewhat higher SNR if identification with a high level of confidence is required. It is reasonable to require that the  $L^3TV$  SNR exceed 6, or  $20 \log(6) = 15.6$  dB.

### A.3 DATA

The spectral intensity of the xenon searchlight source used in the present operational system will be estimated using Figure A2. The SB-100 searchlight draws 20 amperes at 12 volts, or 240 watts, and is collimated approximately 10x. The figure is measured from an uncollimated 5,000 watt xenon source. Therefore, a scaling factor of 24,000/5,000 will be applied to the vertical axis.

The search light filter is a Schott RG 830 shown in Figure A3. The RG 850 filter can also be modeled.

The photocathode can be modeled with the use of Figure A4 which illustrates the spectral response of the XYBION camera currently in use. A negative electron affinity photocathode device would have increased red response and be more useful for this particular application.

The spectral sensitivity threshold of the human eye is obtained by normalizing Figure A5 to  $3 \times 10^{-16}$  watts at 510 nanometers [1].

Choosing nominal values for the remaining unknowns in Equations (9) and (11):

$$\begin{aligned}\Delta_t &= 1/30 \text{ second (interlaced RS-170)} \\ A_t &= 1 \text{ cm}^2 \text{ (for facial identification)}\end{aligned}$$

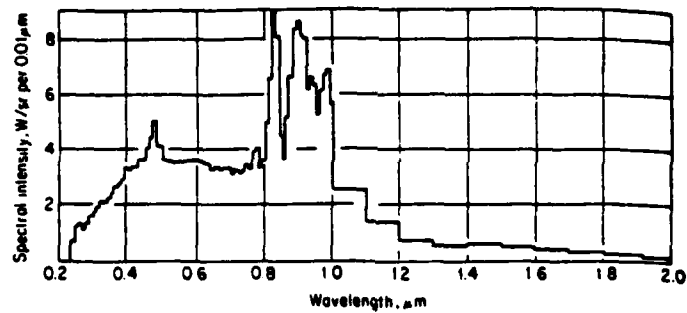


Figure A2. Xenon Lamp Spectral Intensity [4]

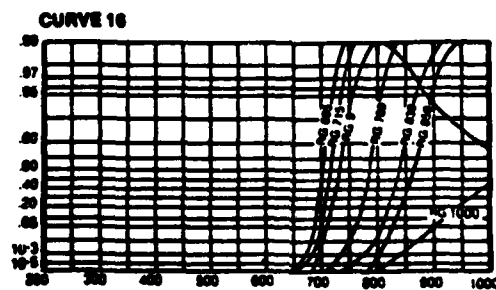


Figure A3. Schott Glass Filter Transmission [5]

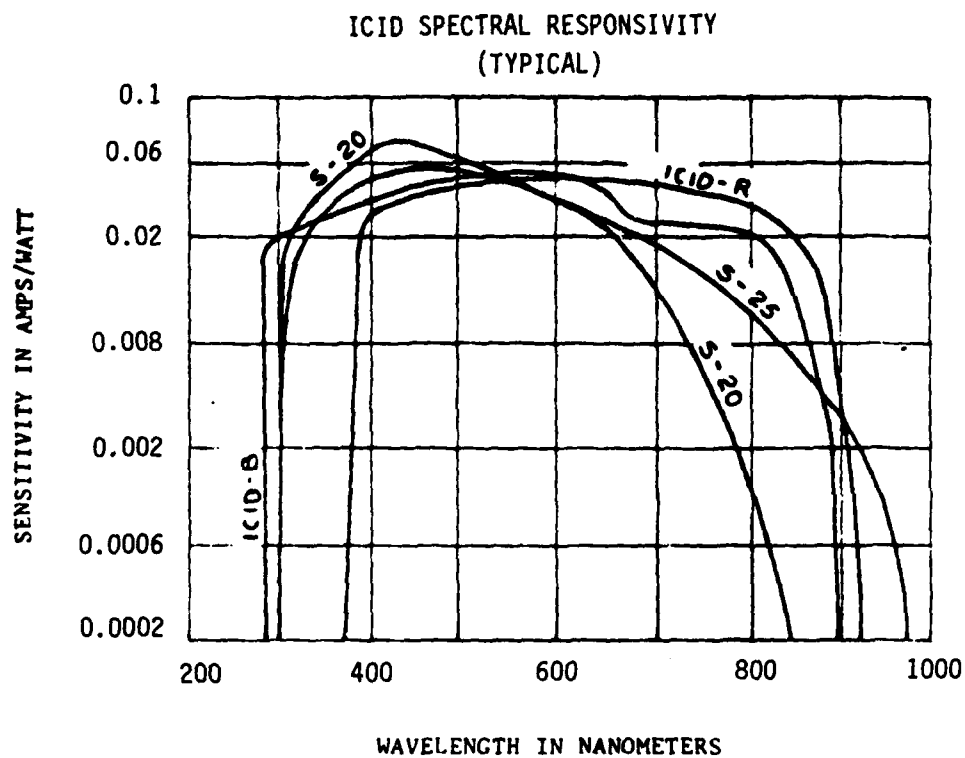


Figure A4. Spectral Response of the XYBION Camera (ICID-R) Compared to Other Conventional Photocathodes

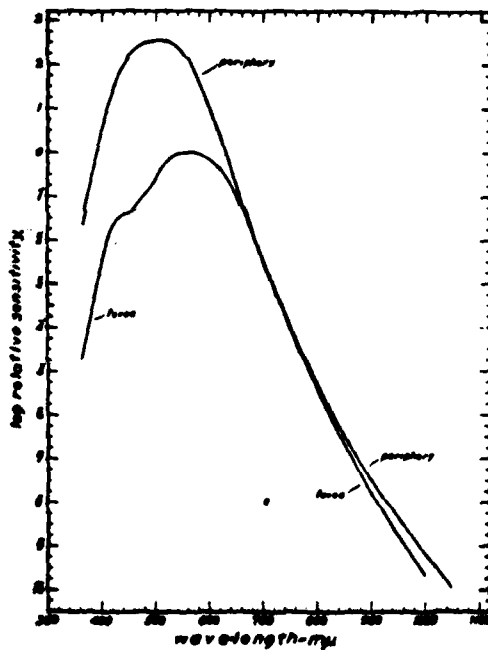


Figure A5. Spectral Sensitivity of the Human Eye [1]

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$$\begin{aligned}
 A_0 &= 75 \text{ cm}^2 \\
 \rho_t(\lambda) &= 0.1 \\
 F_{\text{MCP}} &= 0.8 \\
 A_{\text{eye}} &= 40 \text{ mm}^2 \text{ (dark adapted)}
 \end{aligned}$$

#### A.4 MODELING RESULTS

Figure A6 is an overview of the surveillance system operation to ranges of 200 meters. The fact that the camera dynamic range will not accommodate some of the high SNR's displayed has been ignored to illustrate the functional form of SNR with distance. Applying a fixed SNR ceiling would produce a flat plateau in the high SNR region. Examination of Figure A6 reveals an  $R^{-2}$  SNR dependence along the axes and an  $R^{-4}$  dependence along the diagonal from the origin to the (200,200) point.

The amount by which the searchlight brightness exceeds the dark-adapted eye threshold is shown as a function of eye to illuminator range in Figure A7. The light source is easily visible under favorable conditions at ranges in excess of 200 meters.

The quantity of interest is the TV SNR when the searchlight intensity is decreased to equal the eye threshold at the target distance. This can be obtained with the present model by taking the difference (in dB space) between the diagonal of Figures A6 and A7. Figure A8 illustrates that for a 3½ inch aperture, the required 15.6 dB sensor advantage over the eye is achieved at a range of a little more than 40 meters for the present system (RG 830 filter). Figure A9 shows that this range approximately doubles for an aperture diameter doubling to 7 inches. This is expected since the ratio of TV SNR to eye SNR (Equations (9) through (11)) has an  $R^{-2}$  dependence and the aperture area has a  $D^2$  dependence. Increasing the aperture to 11 inches generates tactically useful ranges as shown in Figure A10.

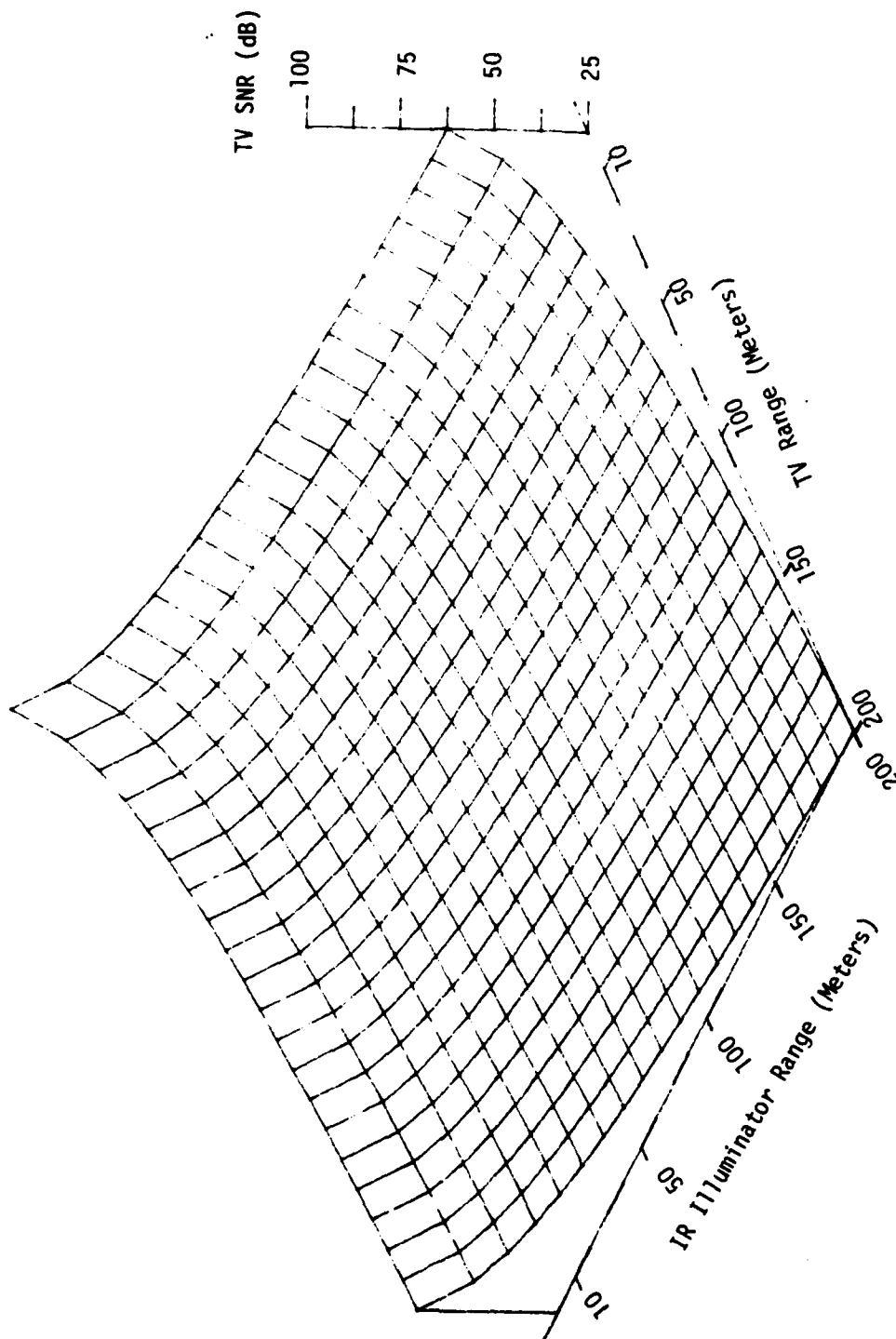


Figure A6. Intensified CCD TV Signal-to-Noise Ratio as a Function of TV Sensor Range and Illuminator Range

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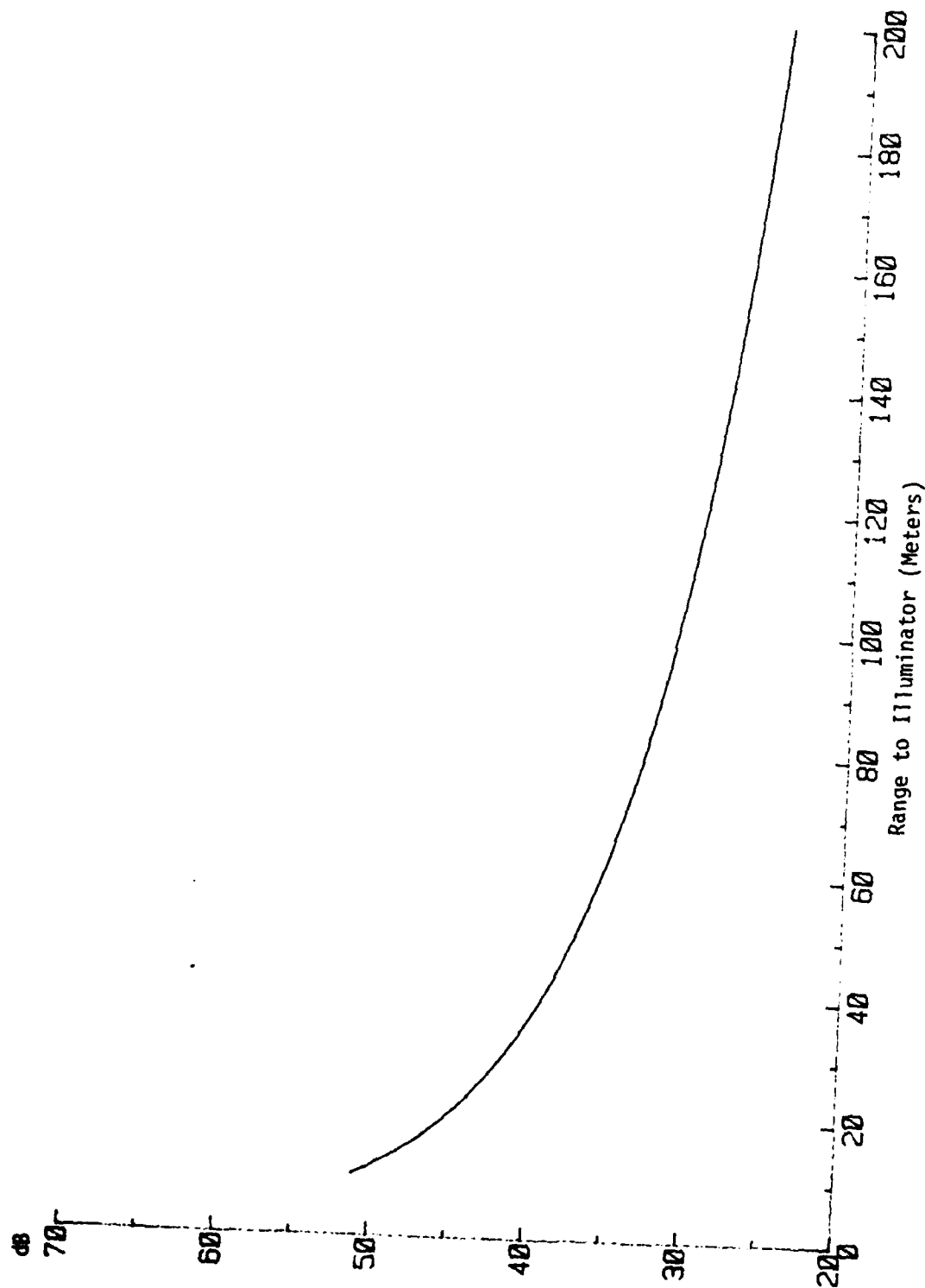


Figure A7. Signal-to-Eye-Threshold vs. Range to Illuminator

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A11

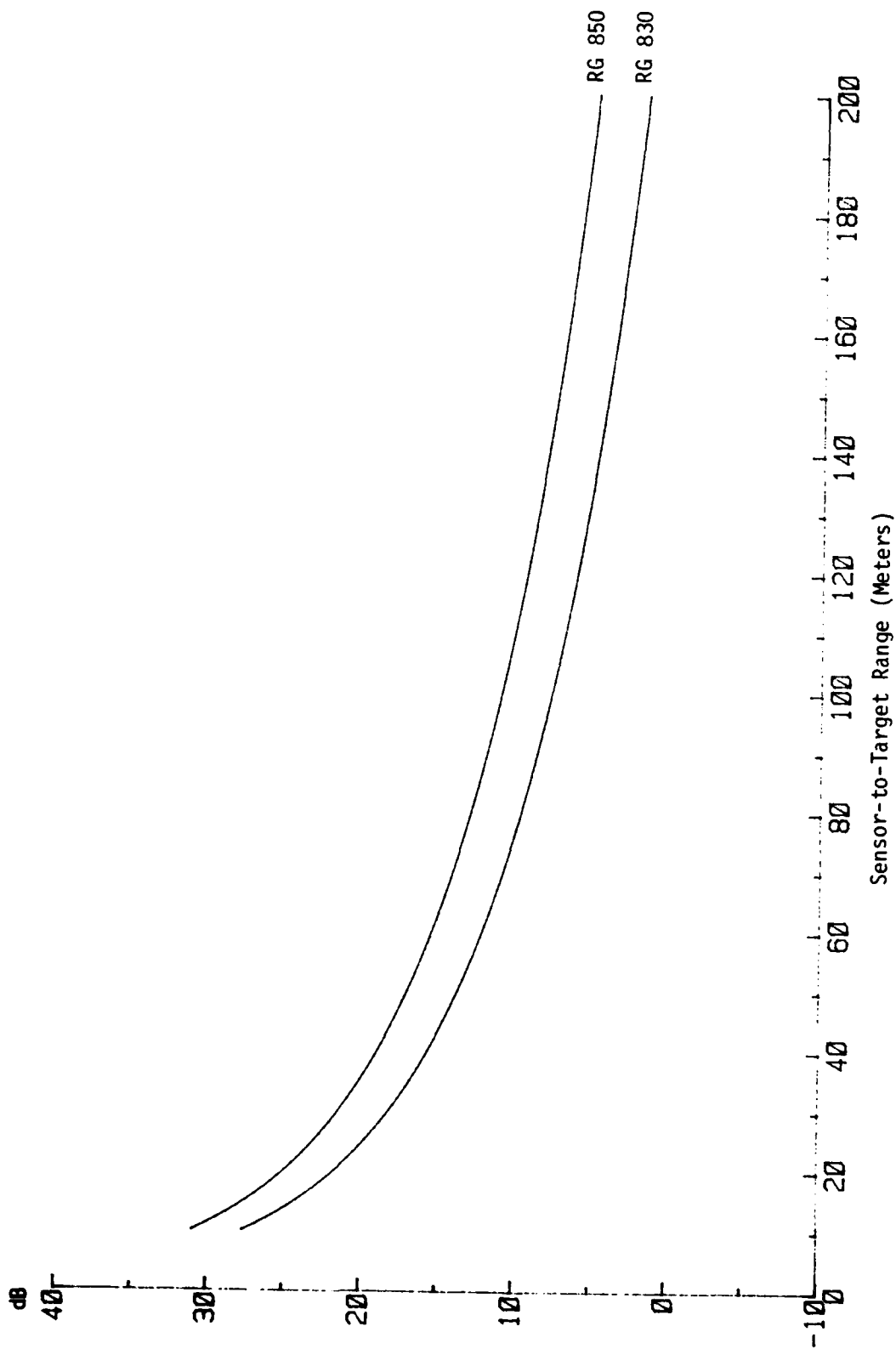


Figure A8. TV SNR Excess at the Sensor Over Eye Signal-to-Threshold at the Target for a Sensor of 75 cm<sup>2</sup> Area (3½ inch aperture with central obstruction)

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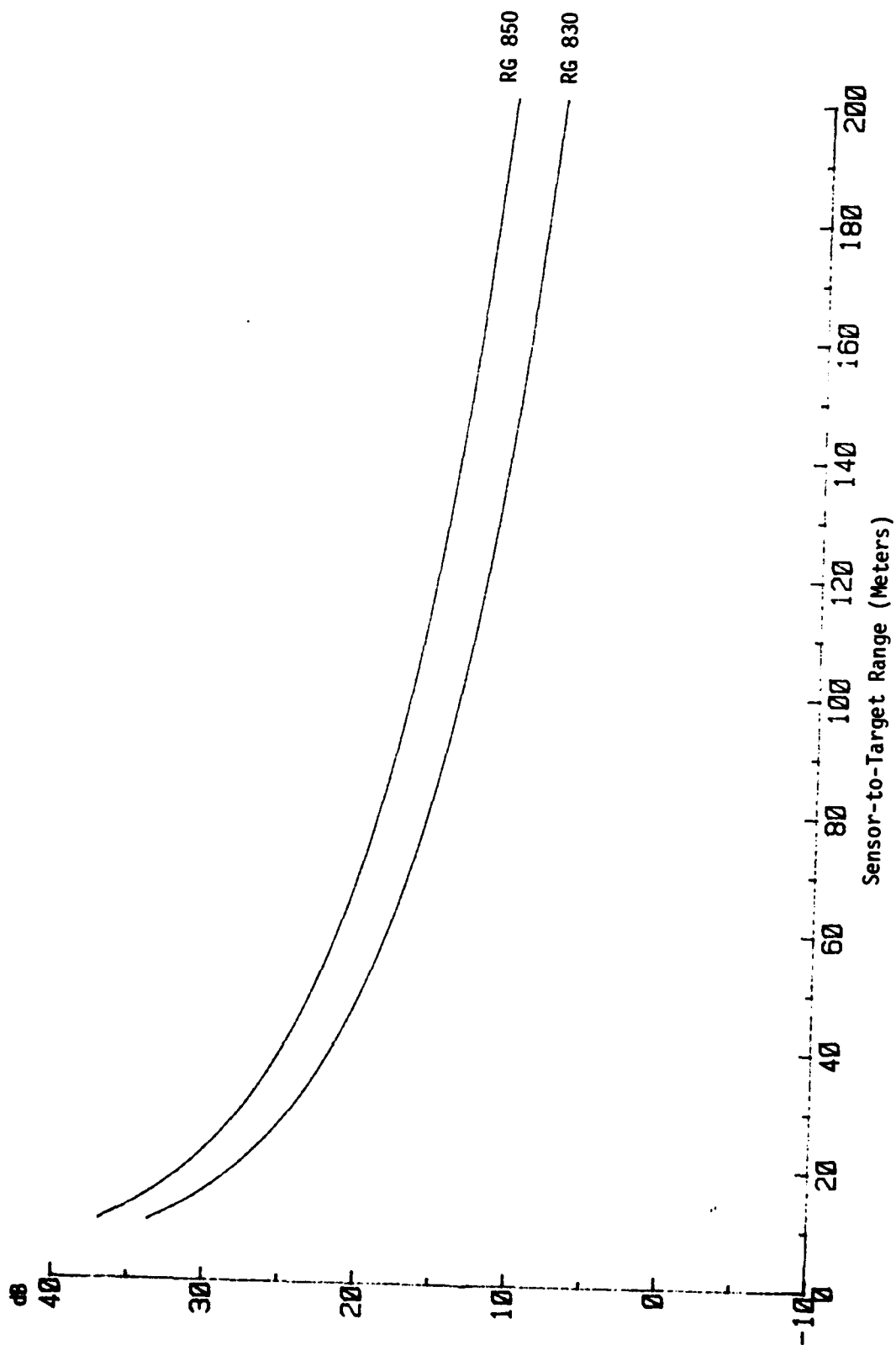


Figure A9. TV SNR Excess at the Sensor Over Eye Signal-to-Threshold at the Target for a Sensor of 300 cm<sup>2</sup> Area (7 inch aperture with central obstruction)

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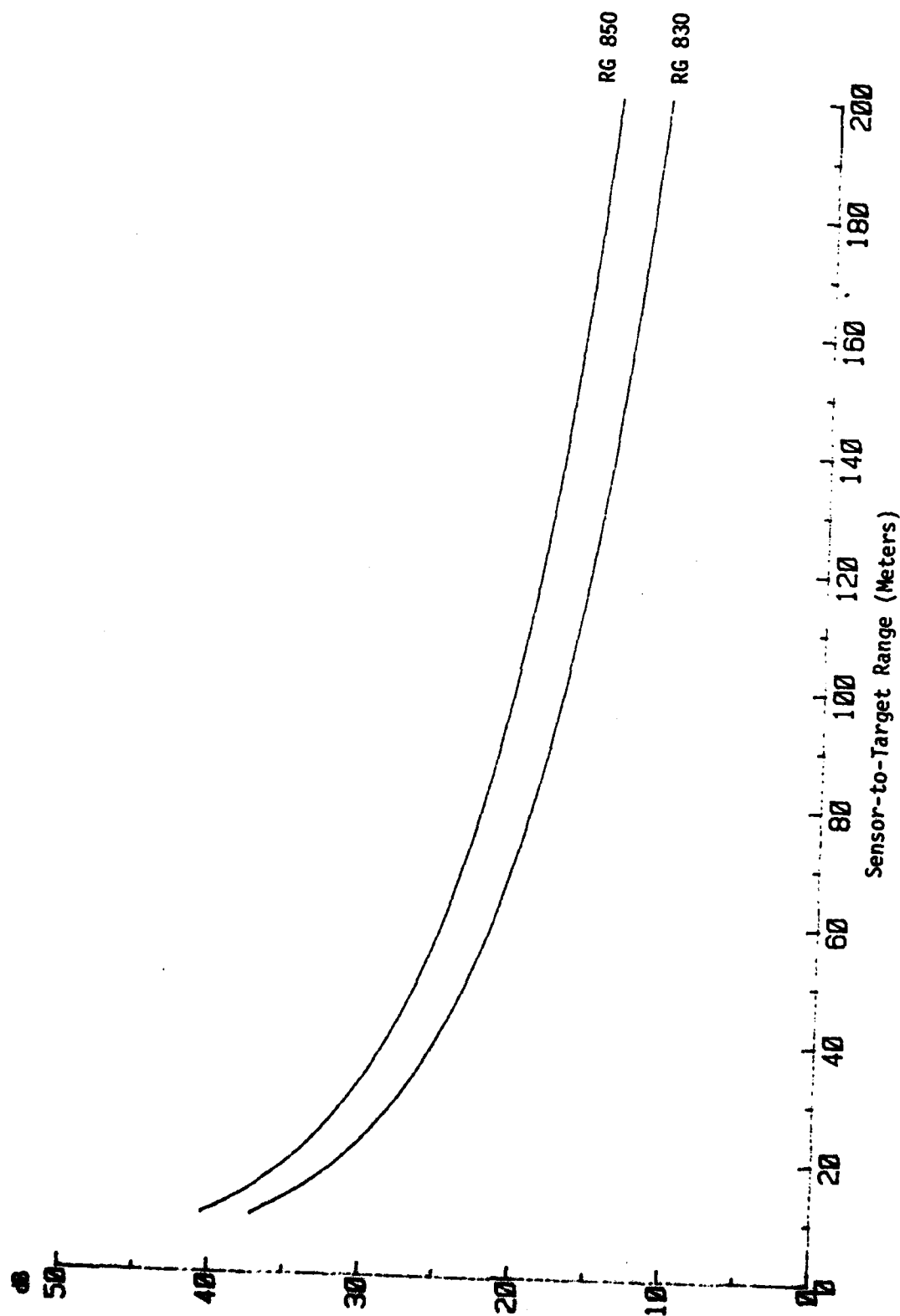


Figure A10. TV SNR Excess at the Sensor Over Eye Signal-to-Threshold at the Target for a Sensor of 675 cm<sup>2</sup> Area (11 inch aperture with central obstruction)

S-147-85

## A.5 DISCUSSION

The eye response to wavelengths beyond 800 nanometers is non-negligible when the  $R^2$  advantage apparent from an examination of Equations (9) and (11) is considered. Varying the illuminator distance independently of the sensor distance has no effect on the problem, since the illuminator to target distance disappears in the ratio of Equations (9) to (10).

The XYBION camera has a decreasing quantum efficiency with wavelength because of the effort XYBION has made to obtain a flat response in the responsivity units of Figure A4. The quantum efficiency can be calculated from the responsivity:

$$\eta = \frac{R_i}{0.808\lambda} \quad , \quad (12)$$

where  $R_i$  is in amperes per watt and  $\lambda$  is in micrometers. Photocathodes exist with  $\eta$  in excess of 0.1 at 800 nanometers, while the XYBION has  $\eta < 0.05$  at this wavelength.

The only complete solution to the problem while using the current SB-100 illuminators is to increase the aperture area to at least  $675 \text{ cm}^2$  while maintaining the minimum illuminator intensity necessary for an acceptable TV SNR.

The only solution which does not require illumination level adjustment is to use a different illuminator and sensor which operate outside the eye's spectral response. A  $1.06 \text{ }\mu\text{m}$  laser illuminator and an S-1 intensifier response is an example of such a system.

APPENDIX A  
REFERENCES

1. Griffin, D. R., R. Hubbard and G. Wald, "The Sensitivity of the Human Eye to Infra-Red Radiation", JOSA, Vol. 37, No. 7, pp. 546-554 (July 1947).
2. SB-100 High Intensity Searchlight with Schott RG 830 IR Filter, sold by Fairington Technologies, Inc.
3. Dereniak, E. L. and D. G. Crowe, Optical Radiation Detectors, Chap. 5, Wiley (1984).
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APPENDIX B  
ALTITUDE-AZIMUTH MOUNT DRAWINGS

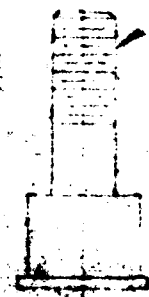
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0002	1	Plate, Bottom		
0003	1	Shaft, Main Upper		
0004	1	Plate, Mount		
0005	1	Plate, Lockdown Cover		
0006	2	Hub, Lockdown		
0007	1	Gear, Azimuth	Browning	P/N BWG24100-1 3/8bore
0008	1	Gear, Altitude	Browning	P/N BWG24100-1 3/8bore
0009	2	Bearing, Main		17mm ID x 40mm OD x 12mm L
0010	1	Housing, Main		
0011	2	Gear, Worm	Boston	GLUH 12924
0012	1	Shaft, Mount Driver		
0013	1	Shaft, Mount Floating		
0014	2	Housing, Worm		
0015	2	Switch, Altitude Stop	Micro Switch	
0016	2	Bearing, Large	Berg	P/N B7-42
0017	4	Bearing, Worm		
0018	2	Shaft, Worm		
0019	2	Bearing, Small	Berg	P/N B7-41
0020	2	Plate, Motor Mount		
0021	1	Housing, Altitude		
0022	1	Plate, Altitude Housing Cover		
0023	2	Motor	Portascap	P/N B 216E
0024	2	Gearbox	Portascap	P/N B-24
0025	1	Support, Mount Plate		

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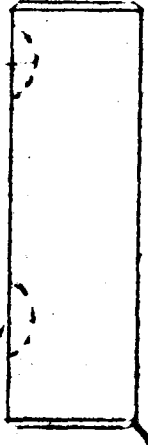
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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:		CONTRACT NO.	
FRACTIONS	DECIMALS	APPROVALS	DATE
1/64	0.003	DRAWN BY <i>[Signature]</i>	
ANGLES		CHECKED	
30°		ISSUED	
PICK STOCK 303 CRES		SHAFT, MOUNT DRIVER	
DO NOT SCALE DRAWING		SIZE	DWG. NO.
		A	0005-0012
		SCALE	SHEET
		2/1	1001

REVISION 1001

REVISIONS

DESCRIPTION

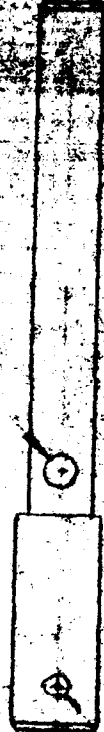
LTR

AGE (mm) 100  
100

906

125

Beam Thickness  
Press 10



781

2.106

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
TOLERANCES ARE

1/16 .001 .002 .003 .004 .005 .006 .007 .008 .009 .010 .015 .020 .030 .040 .050 .060 .070 .080 .090 .100 .125 .150 .175 .200 .250 .300 .375 .400 .500 .600 .750 .800 .900 1.000 1.250 1.500 1.750 2.000 2.500 3.000 3.750 4.000 5.000 6.000 7.500 8.000 9.000 10.000

DATE 10/1/03

10/1/03

10/1/03

10/1/03

10/1/03

10/1/03

10/1/03

10/1/03

CONTRACT NO.

APPROVALS

DATE

10/1/03

10/1/03

10/1/03

10/1/03

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10/1/03

10/1/03

CONTRACT NO.

APPROVALS

DATE

10/1/03

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CONTRACT NO.

APPROVALS

DATE

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CONTRACT NO.

APPROVALS

DATE

10/1/03

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CONTRACT NO.

APPROVALS

DATE

10/1/03

10/1/03

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CONTRACT NO.

APPROVALS

DATE

10/1/03

10/1/03

10/1/03

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10/1/03

10/1/03

10/1/03

FIG. NO.

REVISIONS

NO.	DESCRIPTION

100

125

1250

200

2075

2075

10

QTY 1	ITEM NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	PARTS LIST			
CONTRACT NO.				DATE			
APPROVALS				DRAWN			
CHECKED				ISSUED			
MATERIAL				SCALE			
ALUM				A			
BLK				F4			
DO NOT SCALE DRAWING				SCALE			

# REVISIONS

DESCRIPTION

3765



3767

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
TOLERANCES ARE

FRACTIONS DECIMALS ANGLES

1/16 3/32 1/4 1/2 3/4 1 1 1/2 2 3 4 5 6 8 10 12 16 20 24 32 40 48 60 72 96 120 144 180 216 240 270 300 360

MATERIAL

PIC STOCK  
303

FINISH

DO NOT SCALE DRAWING

CONTRACT NO.

APPROVALS

DATE

DRAWN

CHECKED

DRAWING NO.

CODE IDENT NO.

SIZE

A

SCALE

SHEET

OF

SHAFT, MOUNT FLOATING

# REVISIONS

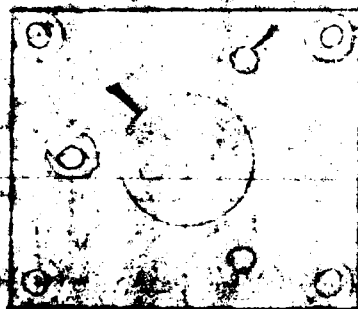
1.00

1.00

875

437

362 362



PLATE, MOTOR MOUNT  
ESCAPES 424

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
FRACTIONS DECIMALS ANGLES

1/1 XX 1/1

1/1 XX 1/1

1/1 XX 1/1

1/1 XX 1/1

1/1 XX 1/1

1/1 XX 1/1

1/1 XX 1/1

1/1 XX 1/1

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APPROVALS

DATE

6-2-55

6-2-55

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6-2-55

SIZE

CODE IDENT NO.

0005-0020

0005-0020

0005-0020

0005-0020

0005-0020

0005-0020

0005-0020

0005-0020

0005-0020

0005-0020

0005-0020

SCALE

1/1

1/1

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1/1

1/1

1/1

DO NOT SCALE DRAWING

DO NOT SCALE DRAWING

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DO NOT SCALE DRAWING

DO NOT SCALE DRAWING

DO NOT SCALE DRAWING

APPLICATION

APPLICATION

APPLICATION

APPLICATION

APPLICATION

APPLICATION

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APPLICATION

APPLICATION

SHEET

1

OF 1

OF 1

OF 1

OF 1

OF 1

OF 1

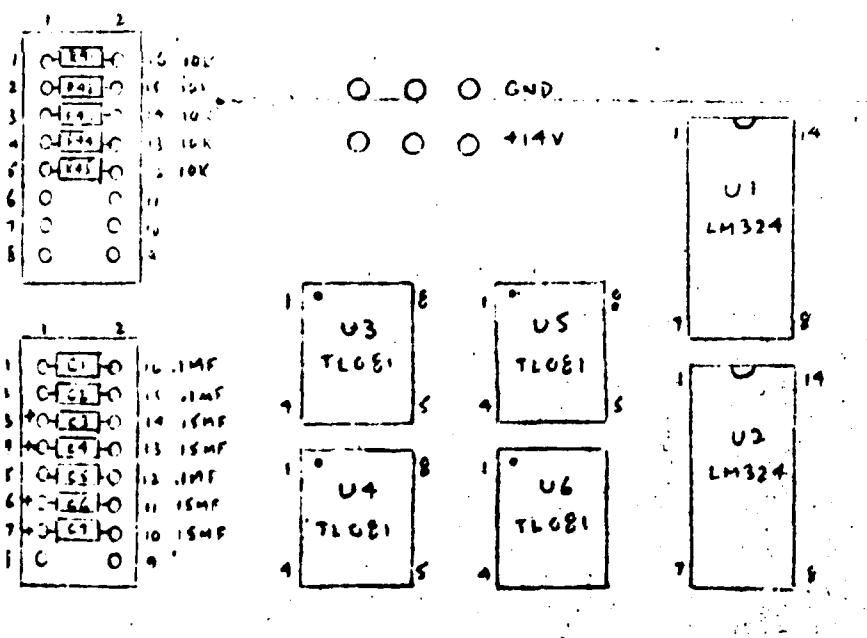
OF 1

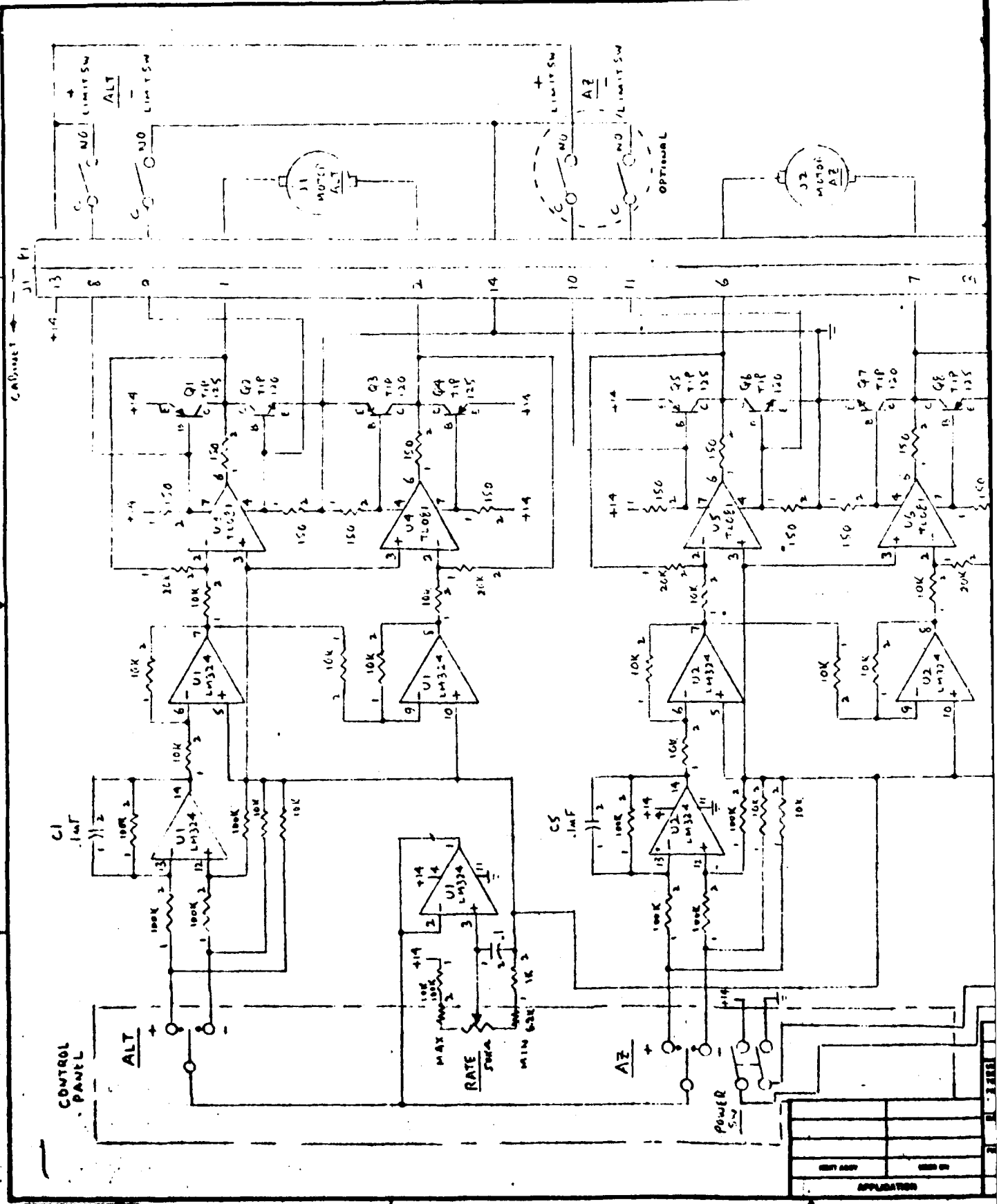




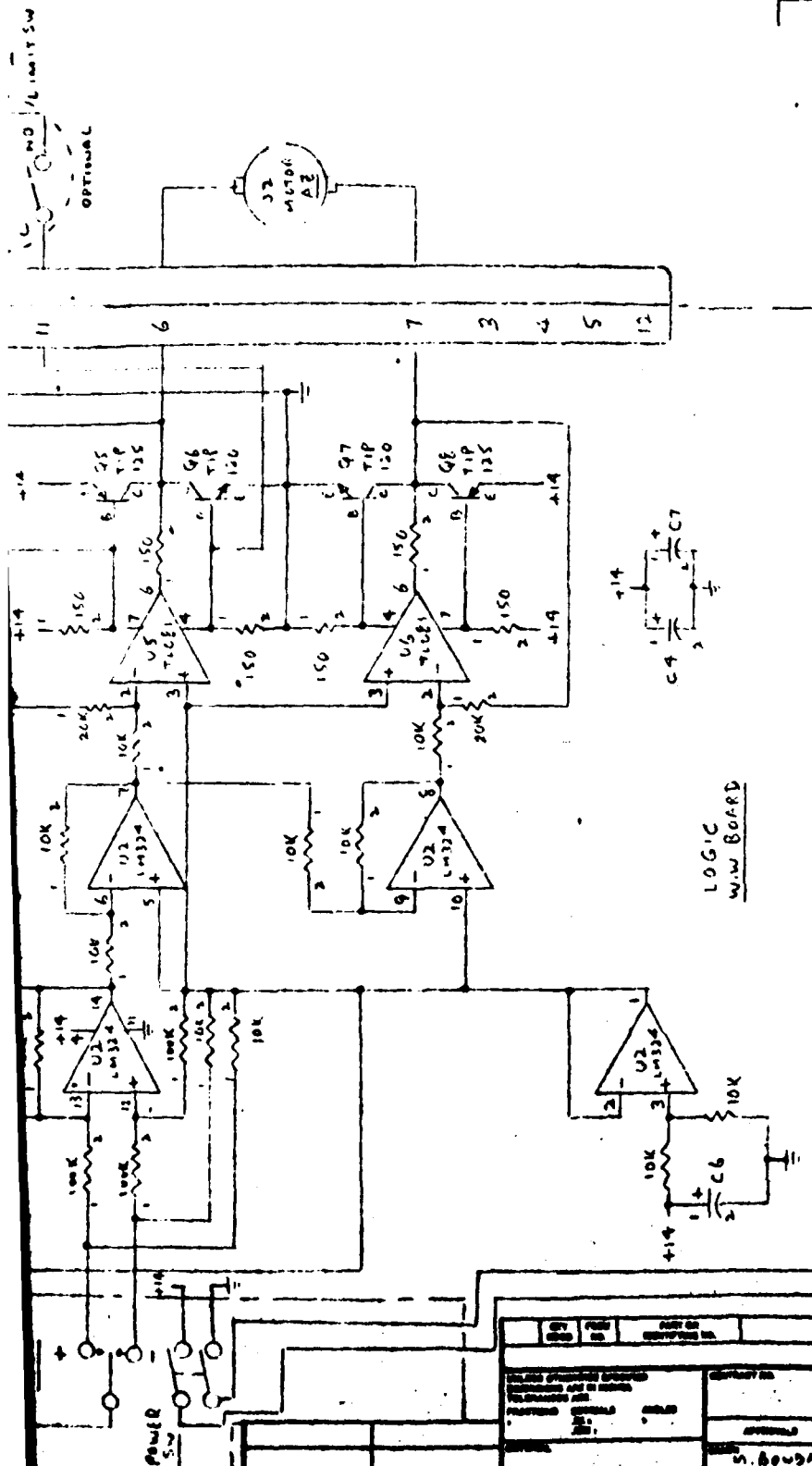
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REVISIONS				
DATE	REV.	DESCRIPTION	DATE	APPROVED

[illegible]



APPLICATION	
TEST APP	USE IN

[illegible]

LOGIC  
W.W. BOARD

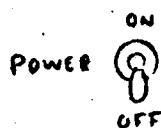
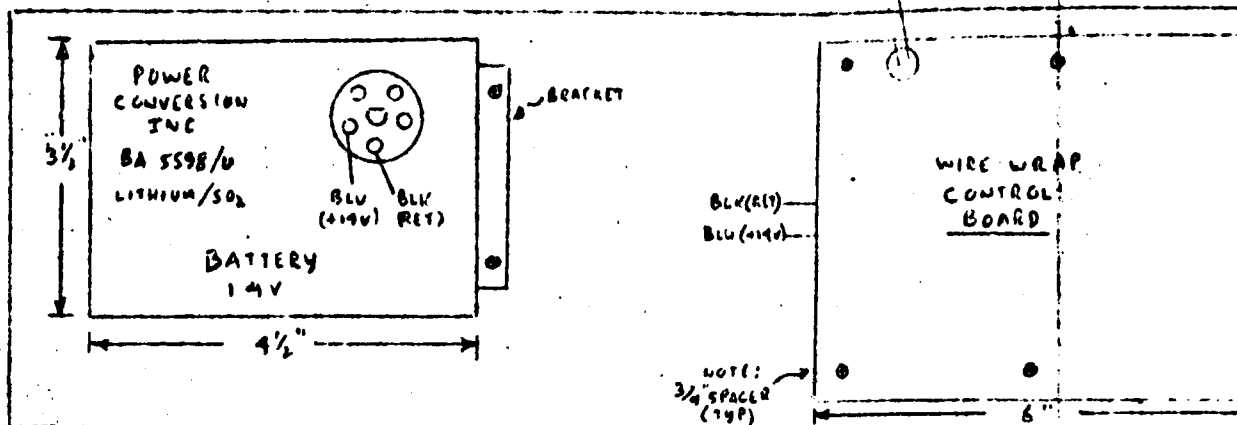
62700  
+148

2

[illegible]

3

TO 21 (BACK PANEL)  
AND CONTROL PANEL



A2



**BACK PANEL**

51 (14th Avenue Connector)



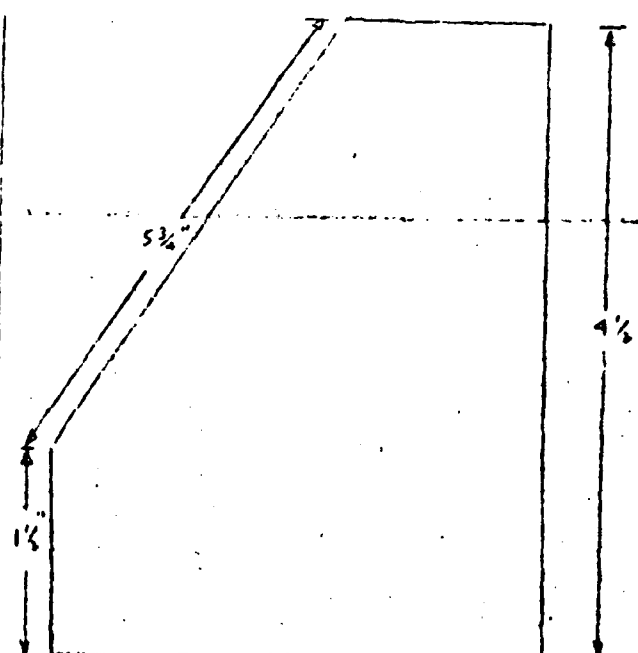
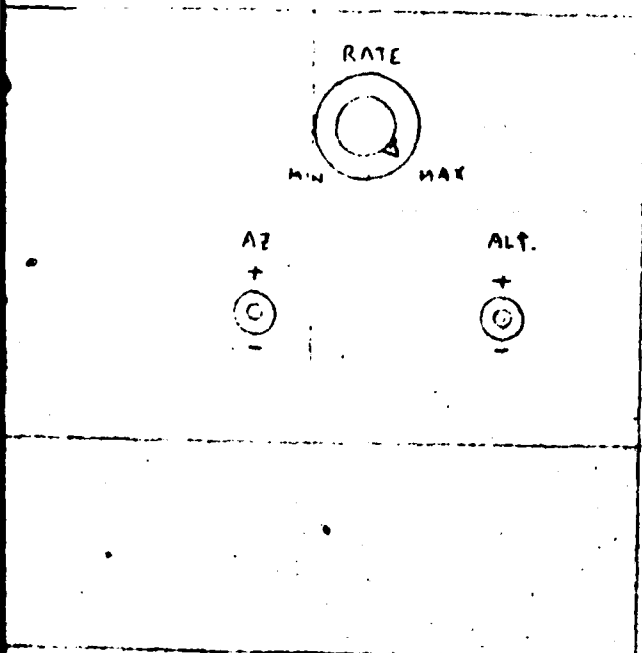
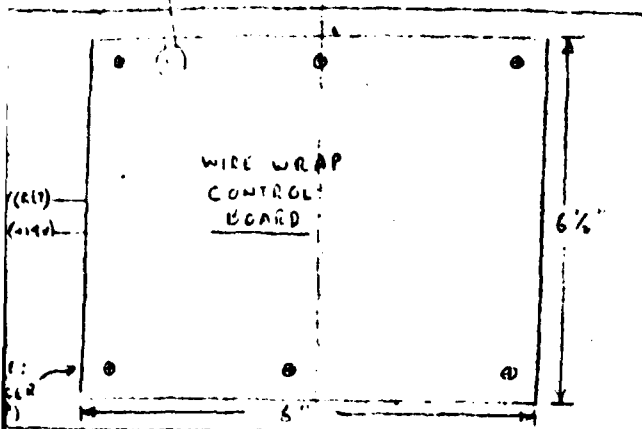
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95	96
97	98
99	100

1


REVISIONS				
DATE	REV	DESCRIPTION	DATE	APPROVED

TO 31 (BACK PANEL)  
AND CONTROL PANEL

A VIEW

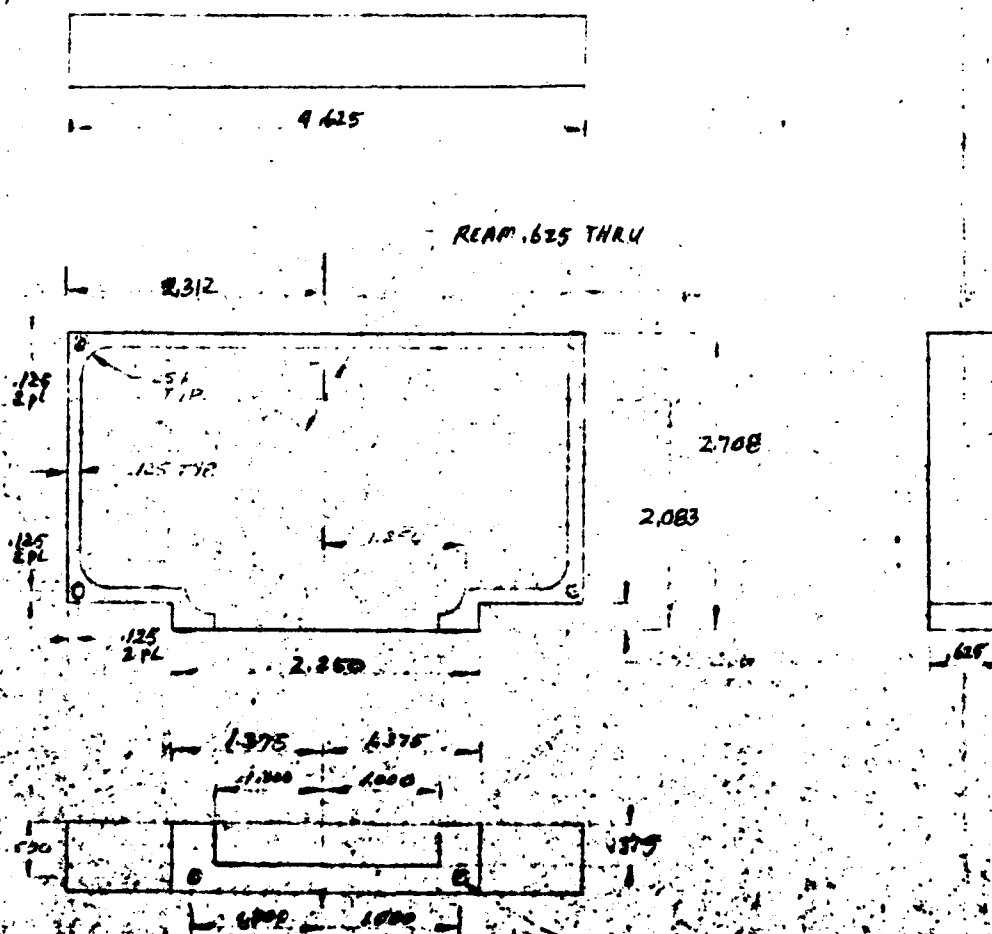


NO CONVECTION

QTY REQD		PANEL NO.		PART OR DESCRIPTION		QUANTITY ON HAND		REMARKS	
PARTS LIST									
CLASSIFICATION SYMBOLS CONTROLLING AGENT'S SYMBOL ALPHABETIC CODE FUNCTIONAL SYMBOL				SYMBOL NO.		 <b>DELTA TAU</b> DATA SYSTEMS			
				SYMBOL NO.		ASSY.			
				SYMBOL NO.		CABINET			
				SYMBOL NO.		TELESCOPE POSITIONER			
REV. NO.				REV. NO.		REV. NO.		REV. NO.	
601972-100				601972-100		601972-100		601972-100	
APPROVED				DO NOT SCALE DRAWING		SCALE		SHEET 1 OF 1	

3

C

**B**

ĐẢNG CỘNG SẢN VIỆT NAM

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85	86
87	88
89	90
91	92
93	94
95	96
97	98
99	100

REV VISIONS				
ZONE	REF	DESCRIPTION	DATE	APPROVED

DRILL # 32 THRU 4  
CORE 167 116 D 4

250

4.025

2312

2063

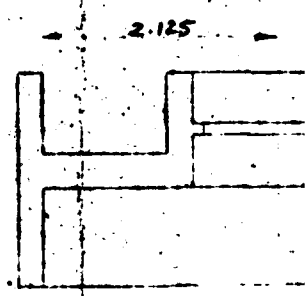
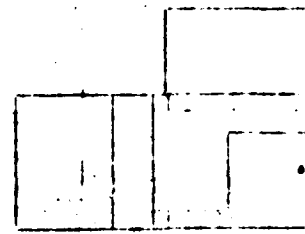
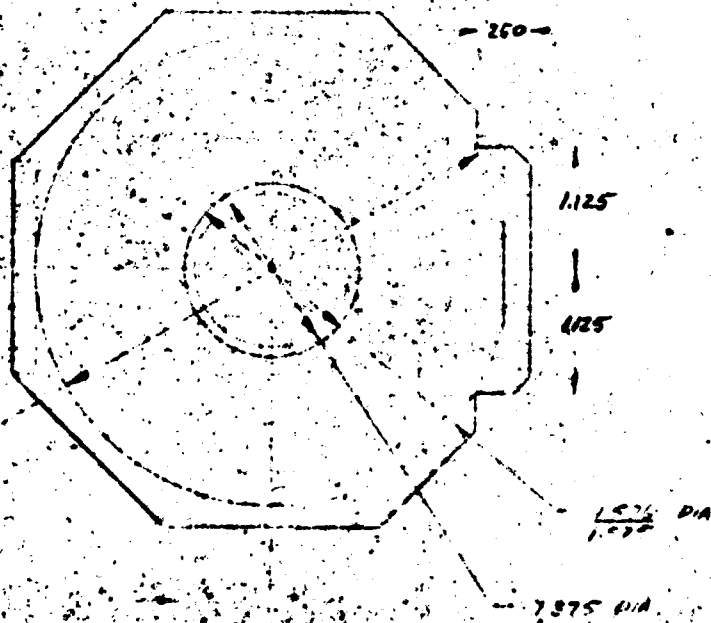
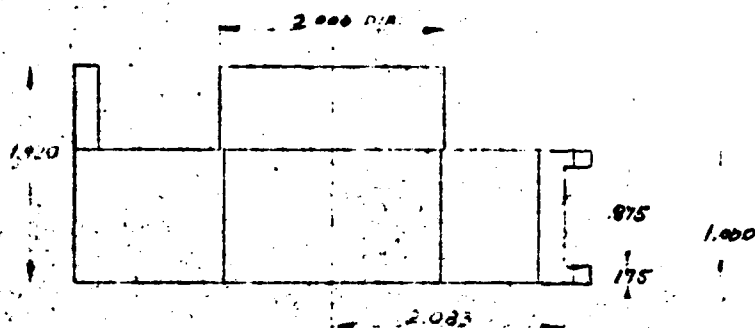
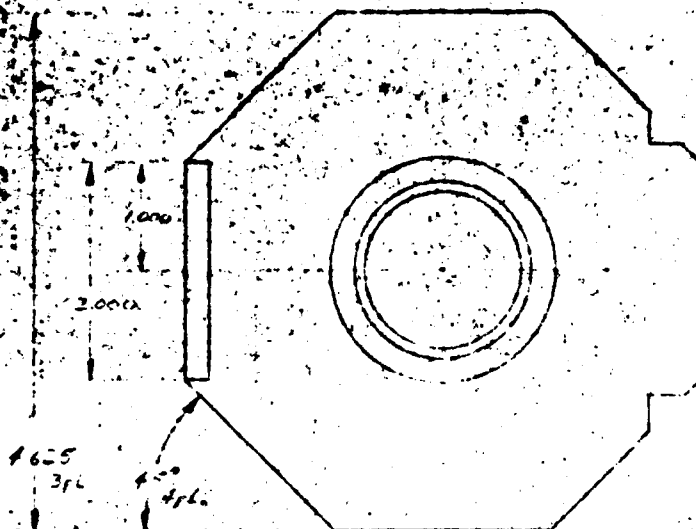
2708

250

DATE 0005-2

[illegible]

3



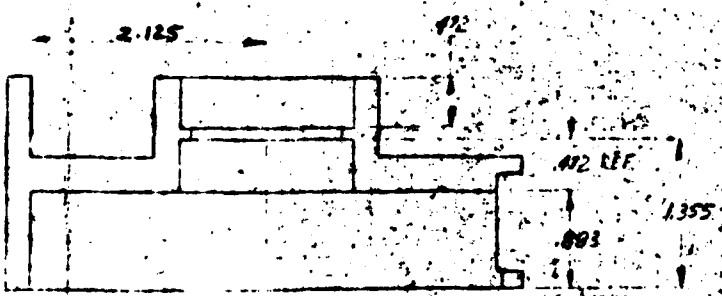
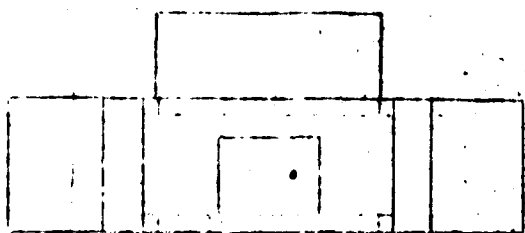


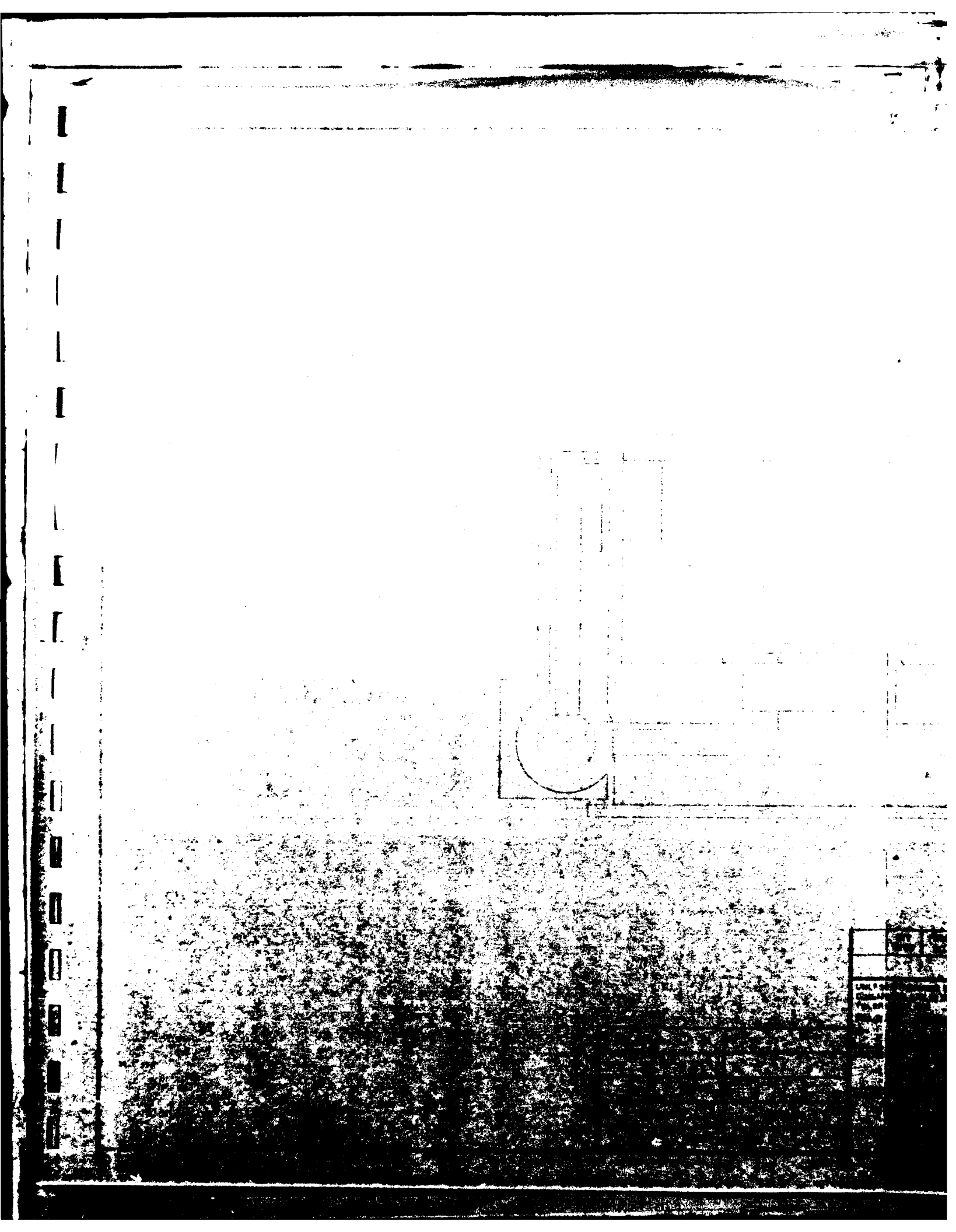

3

2

1

REVISIONS				
DATE	REV	DESCRIPTION	BY	APPROVED

[illegible]



# REVISIONS

DATE

APPROVAL

REV  
NO

PCB  
NO

PART OR  
IDENTIFYING NO.

REVISIONS  
OR DESCRIPTION

PARTS LIST

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
TOLERANCES ARE

FRACTIONAL DECIMALS ANGLES

ALL C

FIN

WELD

DRILL

REAM

TURN

GRIND

ETCH

PLATE

POWDER

COAT

PAINT

ANNEAL

TEMPER

STRAIN

RELIEF

STRESS

RELIEF

BORE/REAM THRU  
375 NEAR WALL  
412 FOR WALL

DWG. NO.

SH

REV.

REVISIONS

REV.

DESCRIPTION

DATE

APPROVED

.312

DRILL #32 THRU  
+ C BORE FOR #4 CAP SCREW  
FAR SIDE 4PL.

31L

1.16

.125  
2PL.

2.000

2

REV.

FORM

PART OR IDENTIFIED NO.

DESCRIPTION OF REVISION

DATE

APPROVED

PARTS LIST

REVISIONS SPECIFIED  
BY THE ENGINEER  
AND THE WORKMAN

REVISIONS  
NO. 1  
DATE 11-1-77

REVISIONS  
NO. 2  
DATE 11-1-77

REVISIONS  
NO. 3  
DATE 11-1-77

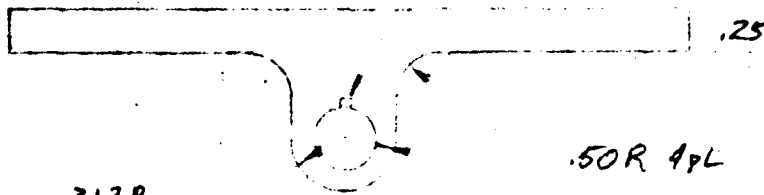
REVISIONS  
NO. 4  
DATE 11-1-77

REVISIONS  
NO. 5  
DATE 11-1-77

REVISIONS  
NO. 6  
DATE 11-1-77

REVISIONS  
NO. 7  
DATE 11-1-77

BROACH  $\frac{1}{16}$  KEY SLOT



.312R  
6PL

.50R 4PL

REAM .3750 THRU.



4.000

.875

2.000

.375 2PL

.125 2PL

.1250

REV	DATE	BY	CHKD
1			
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QW 10

SM

REV

REVISIONS

REV

DESCRIPTION

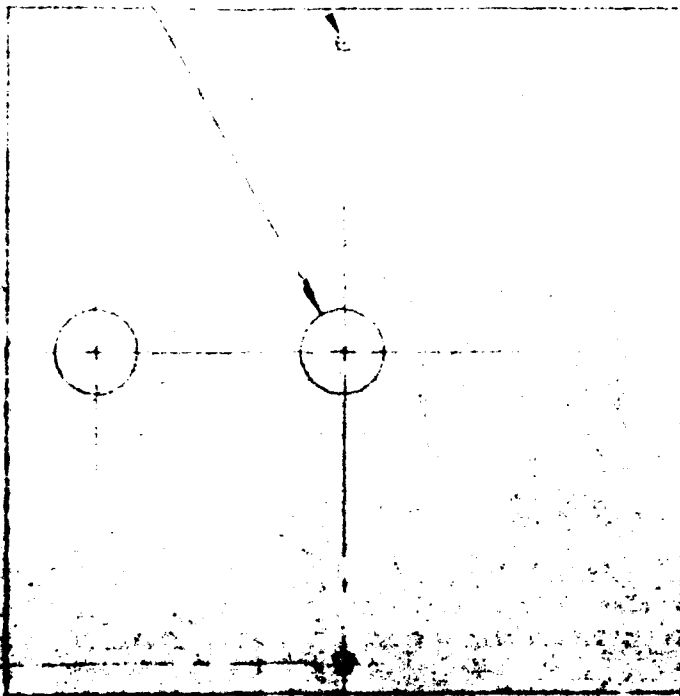
DATE

APPROVED

500<sup>1000</sup> THRU  
2PL

1RU.

TAP 14-10 UNC 1/2  
2PL



.125

.187 2PL

QTY

PCB

REV

DATE

DATE LIST

A

44250

3.2

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
TOLERANCES ARE:



DWG. NO.

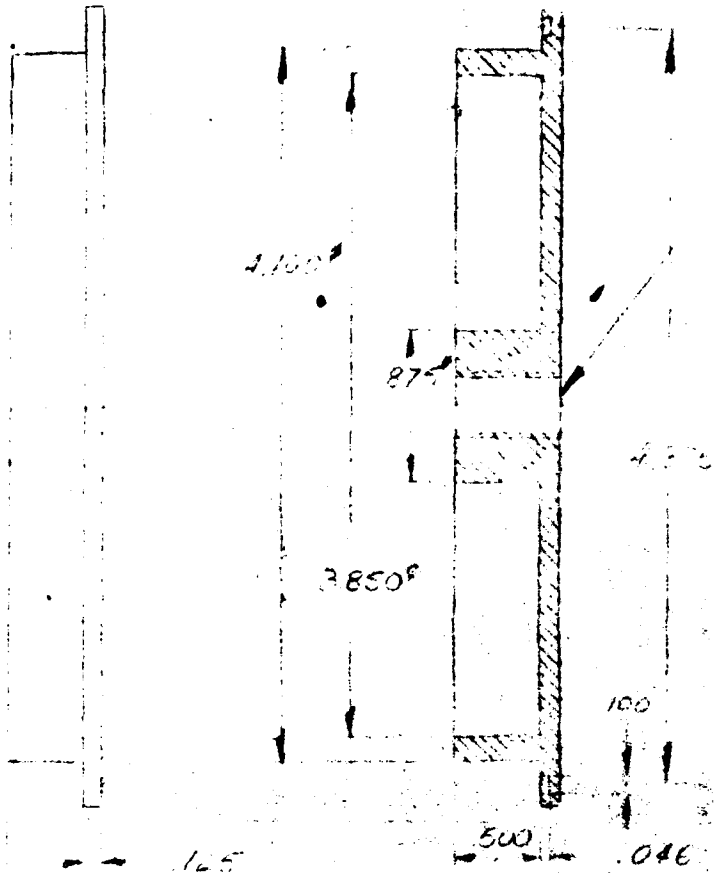
REV

DESCRIPTION

DATE

SHEET

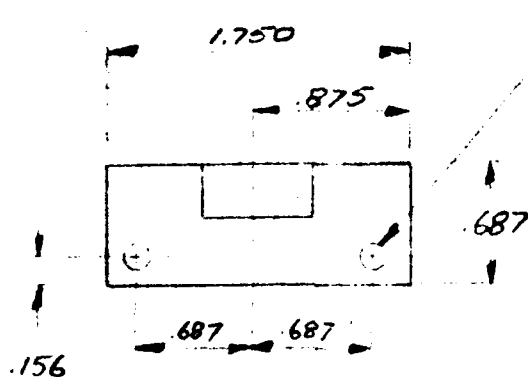
VEL  
DP.



DRILL 1/2" DIA. 4 H. T.H.F.

SECTION A-A

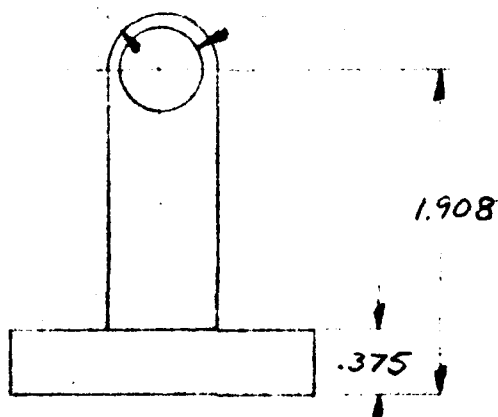
QTY REQD	PCEN NO	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	INTERNAL SPECIFICATION
PARTS LIST				
CONTRACT NO.				
OTHERWISE SPECIFIED				
DIMENSIONS ARE IN INCHES				
TOLERANCES ARE:				
FRACTIONS DECIMALS ANGLES				
1/16 0.0625 15				
1/32 0.03125 30				
1/64 0.015625 60				
1/128 0.0078125 120				
1/256 0.00390625 240				
1/512 0.001953125 480				
1/1024 0.0009765625 960				
1/2048 0.00048828125 1920				
1/4096 0.000244140625 3840				
1/8192 0.0001220703125 7680				
1/16384 0.00006103515625 15360				
1/32768 0.000030517578125 30720				
1/65536 0.0000152587890625 61440				
1/131072 0.00000762939453125 122880				
1/262144 0.000003814697265625 245760				
1/524288 0.0000019073486328125 491520				
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DRILL #18 THRU.  
2 PL.

.625 R.

REAM .501 THRU.



NEXT ASSY	USED ON
APPLICATION	

UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN FRACTIONS
1/16
6
FINISH
DRILL

DWG. NO.

SH

REV

## REVISIONS

REV

DESCRIPTION

DATE

APPROVED

312



2

QTY REQD	PDCM NO	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION		MATERIAL SPECIFICATION
PARTS LIST					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FRACTIONS DECIMALS ANGLES $\frac{1}{16}$ .01 $1^\circ$ $\frac{1}{32}$ .003		CONTRACT NO.			
MATERIAL 6061 ALUM. BLK ANOD. DO NOT SCALE DRAWING		APPROVALS DESIGNED <i>W. J. Smith</i> CHECKED <i>W. J. Smith</i> ISSUED	DATE 5/2/65	SUPPORT, MOUNT PLATE	
		SIZE B	PDCM NO.	DWG. NO. 0005-0025	REV
		SCALE FULL	SHEET 1 OF 1		

DATE

FILMED

5-8